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PRELIMINARY ISSUE

650.6301

Job Sheet 211105



Report

5299728

Part No: 650.6301

Job Qty: 3 pcs

Part Name: Swivel Fitting Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/6/20

Job Tracking No:

Due Date: 8/20/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: 650.6300 REV.PG2 IPP REV:A 20.06.15 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	3 pcs	8/20/20		0.00	0.50	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
120	QC 5	3 pcs	8/20/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
130	Packaging 3-1 - Stock - B4B	3 pcs	8/20/20		0.00	0.00	Packaging 3 - 1 - B4B		

8/20/20

DAS
82
9-89

SEP 11 2020

				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS 28 9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	SEP 11 2020
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	3 pcs	8/20/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	

Part Op 110 - ****CRITICAL PART - EXTREME CARE MUST BE TAKEN**** ****MUST ENSURE THE COMPONENTS ARE
 Descriptions: NEVER DAMAGE**** ASSEMBLE AS PER DWG ***SECURE BY STAKING EDGE EVERY 90 DEGREE AS PER
 DWG***
 120 - QC5- Inspect part completeness to step on W/O
 130 - (Identify as per dwg & Stock ****CRITICAL PART - EXTREME CARE MUST BE TAKEN**** ****MUST ENSURE
 THE COMPONENTS ARE NEVER DAMAGE****
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
650.6310	Swivel Fitting	3 pcs (1 ea)	110-Small Fab - 1	528773
650.6312	Screen Retainer	3 pcs (1 ea)	110-Small Fab - 1	328733
650.6313	Screen	3 pcs (1 ea)	110-Small Fab - 1	3289591

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	650.6310	3	0	0
	650.6312	3	0	0
	650.6313	3	0	0

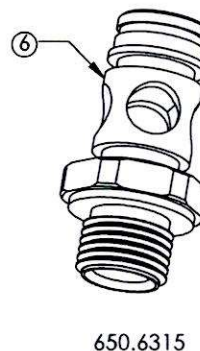
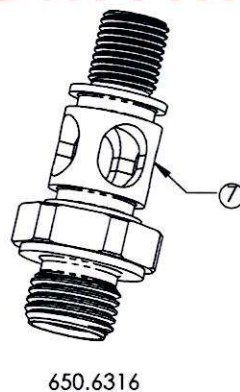
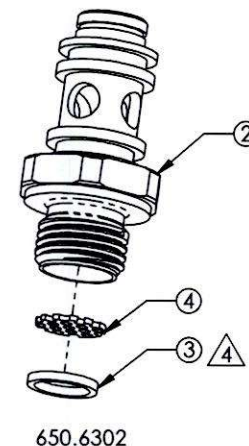
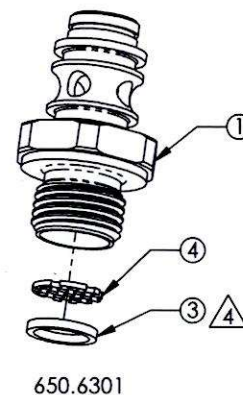
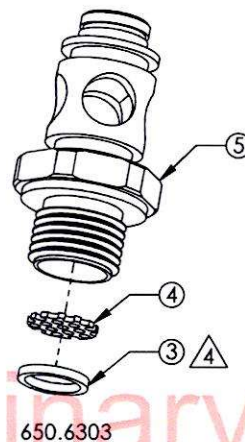
Part Specifications
Specifications could not be found.

Plex 9/10/20 10:34 AM dart.lacelle.linda

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NOTES:

1. DEBURR AND BREAK ALL SHARP EDGES.
2. MATERIAL: 17-4PH H1150 STAINLESS STEEL IAW AMS 5643 OR ASTM A564
3. IDENTIFY IAW MP-120.
4. SECURE F/N 3 BY STAKING EDGE ON F/N 1 OR 2 EVERY 90°. ①
5. MATERIAL: PERFORATED 304 SS SHEET, VENDOR: MCMASTER-CARR. VENDOR P/N: 9358281.
6. FINISH: IAW MPP-172 PASSIVATE IAW SECTION 6.1.
7. TOLERANCES DO NOT APPLY AFTER STAKING (REFER TO FLAGNOTE 4).
8. MATERIAL: 17-4PH H900 STAINLESS STEEL IAW AMS 5643 OR ASTM A564



PROTOTYPE REVISIONS

ZONE	REV	DESCRIPTION	DATE	APPROVED
A4-1 B1-1 B3-2 B4-2 C1-2 C4-2 C8-2 D3-2 D4-2	PG1	ADDED AMS 5643 AND ASTM A564 STANDARDS ADDED AMS 5643 AND ASTM A564 STANDARDS REMOVED ELECTROPOLISH FINISH ADDED DETAIL A DIMENSION WAS $\phi .440 \pm .005$ IS $\phi .426 \pm .002/-0.003$ ADDED DETAIL B ADDED .020 DIMENSION ADDED DETAIL E ADDED $\phi .250 \pm .002 \pm 1.050$ DIMENSION ADDED .075 $\pm .015/-0.000$ DIMENSION ADDED .505 $\pm .002/-0.000$ DIMENSION ADDED MIN THREAD RELIEF CALLOUT ADDED DETAIL S DIMENSION WAS $\phi .440 \pm .005$ IS $\phi .426 \pm .002/-0.003$ DIMENSION WAS R.405 IS $\phi .810$ ADDED DETAIL R ADDED .075 $\pm .015/-0.000$ DIMENSION ADDED .710 DIMENSION DIMENSION WAS .050 X 45° 2 PL IS .035 X 45.0° DIMENSION WAS .350 IS (.350)	06/01/2020	T. CROSS
A7-11 B2-11 B3-11 C3-11 C8-11 D5-11 D5-11 B2-12 B4-12	PG2	ADDED ZONE CALLOUTS ADDED DETAIL E AND ZONE CALLOUT DIMENSION WAS $\phi .440 \pm .005$ IS $\phi .426 \pm .002/-0.003$ ADDED .075 $\pm .015/-0.000$ DIMENSION	06/15/2020	T. CROSS

REV	DESCRIPTION	DATE	APPROVED
NC	INITIAL RELEASE	04-28-14	P.BRAVO
A	INCORPORATED ECN 04699	10-08-14	P.BRAVO
B	INCORPORATED ECN 04894	03-11-15	P.BRAVO
C	INCORPORATED ECN 04900	03-19-15	P.BRAVO
D	INCORPORATED ECN 04912	04-01-15	P.BRAVO
E	INCORPORATED ECN 04962 AND 04989	06-30-15	P.BRAVO
F	INCORPORATED ECN 05081	08-12-15	P.BRAVO
G	INCORPORATED ECN 05089	08-14-15	P.BRAVO

		7	650.6316	SWIVEL FITTING	△	△
		6	650.6315	SWIVEL FITTING	△	△
		5	650.6314	SWIVEL FITTING	△	△
1	1	4	650.6313	SCREEN	△	△
1	1	3	650.6312	SCREEN RETAINER	△	△
1	1	2	650.6311	SWIVEL FITTING	△	△
	1	1	650.6310	SWIVEL FITTING	△	△
X			650.6303	SWIVEL FITTING ASSY		
	X		650.6302	SWIVEL FITTING ASSY		
	X		650.6301	SWIVEL FITTING ASSY		

4303	4302	4301	FIN #	PART #	DESCRIPTION	MATL	SPEC.
QTY	PARTS LIST						
NEXT ASSY (S)	ORIGINAL DATE: 04-28-2014 DRAWN BY: N. CAP CHECKED BY: P. BRAVO DRAWINGS APPROVAL: P. BRAVO 04-28-2014 CONTRACT NO.		 DART AEROSPACE AERIAL INDUSTRIES, INC. 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300				
650.5300	SWIVEL FITTING						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .010 3 PLACE DECIMALS ± .005 ANGLES ± .5°			SEE CAGE CODE DWG NO. REV. B 07/MZ6 650.6300 PG2				
SCALE: NONE			SHEET 1 OF 12				

INSPECTION SHEET

DAS
82
9-89

SEP 11 2020Date:

Revised by	
KJ	